

Date: Wednesday, 8/30/2006 11:57:07 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GPS RECEIVER HOUSING
Job Number	: 28358	Part Number	: D35149
Estimate Number	: 12495	Drawing Number	: UNDER REVIEW CB 06.08.30
P.O. Number	:	Project Number	: N/A
This Issue	: 8/30/2006 S.O. No. :	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 9/6/2006 Qty: 1 Um: Each
Previous Run	:		
Written By	: 06.08.30		
Checked & Approved By	: 06.08.30		
Comment	: Est Rev: A New Issue 06-07-26 JLM		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.1969 sf(s)/Unit Total : 0.1969 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: **1700792**

SAD 06.09.03

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: **Pre1**

Prog Rev: **Pre1**

Ensure Grain Direction is correct**

2-Deburr if necessary

SAD 06.09.03

①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06.09.03

①

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06.09.03 ①

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form Joggle as per Dwg D3514

SAD 06.09.03 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 31/03/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 8/30/2006 11:57:07 AM
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Process Sheet

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Drawing Name: GPS RECEIVER HOUSING

Job Number: 28358

Part Number: D35149

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-09-06 (1)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06-09-12 (1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-09-13

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

for eng. use only.

06-09-19 (1)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07-03-08 (1)

Job Completion



06-09-20

Eng Approval

CB 07-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

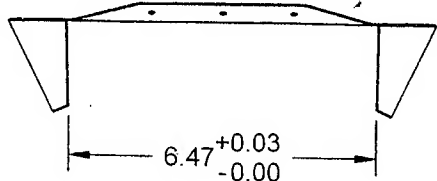
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3514	REV. A
DATE 06.05.03		TITLE GPS RECEIVER HOUSING	SHEET 7 OF 7 SCALE 1:2

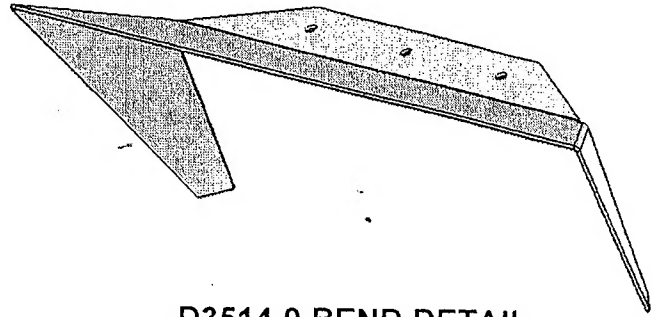
~~UNDER REVIEW~~

~~06/08.23/CB~~

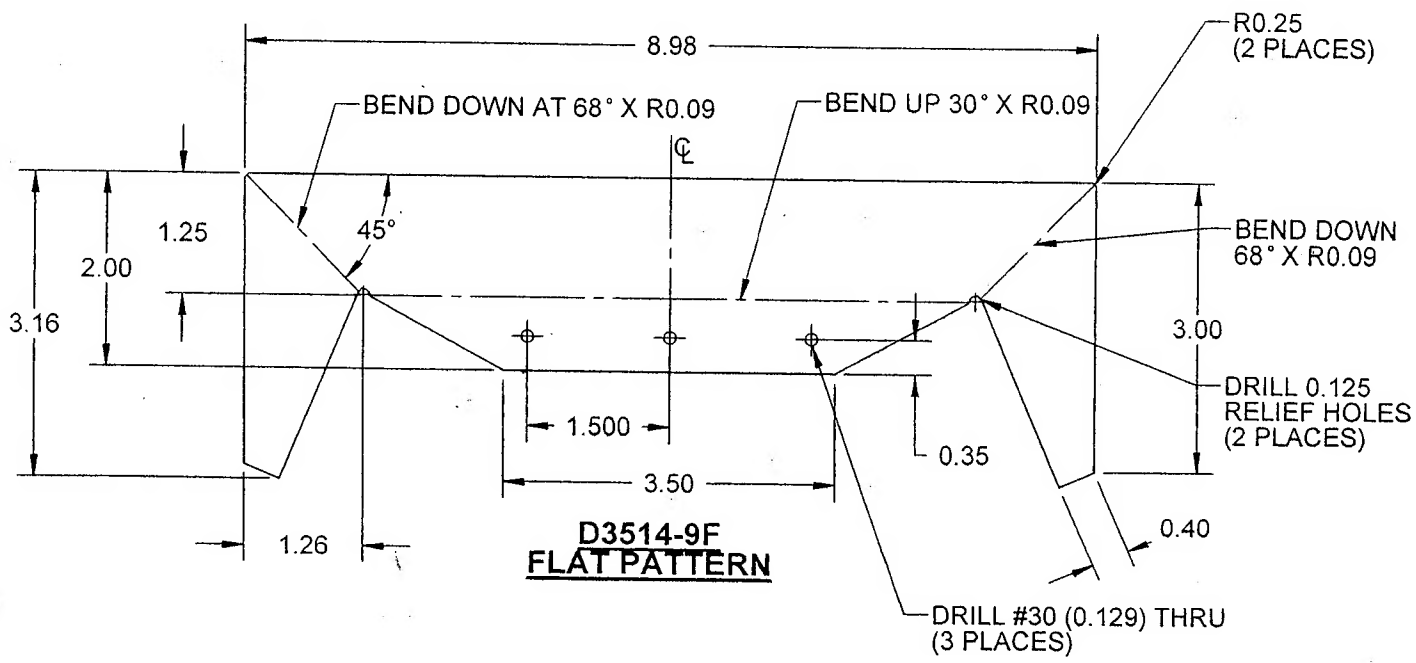
~~prototype~~



FRONT VIEW
SCALE 1:4



D3514-9 BEND DETAIL



D3514-9F
FLAT PATTERN

D3514-9 HOOD

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT ϕ

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
28358

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WORK ORDER **		04/13/06 ORD		TEST RESULTS	
SHIP TO		DELIVERY DATE	SHIP BRANCH	SELL BRANCH	WORK ORDER
01		04/24/06 DEL	30 (04)	30-TOR	UZ3809
AEROSPACE BERDEEN ST BURY ON CANADA K6A 1K7		6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y			
		Copper and Brass Sales Canada A ThyssenKrupp Materials NA company 			
CUSTOMER P.O. NUMBER	TERRITORY	ENTRY ID	CUSTOMER SIGNATURE		
000001005	01	30BXT	DATE:		
NAME	INSIDE SALES	QUANTITY	ORDERED	SHIPPED	
INDA LACELLE	BRIAN TEDESCO	INVENTORY	54.19 LB	52.00	
TELEPHONE	INSIDE SALES TELEPHONE	BILLING	2.00 PC	2.00	
613) 632-9577	(905) 696-8100 37622	WAREHOUSE			
SHIP VIA	SHIPPING STATUS		PACKED WITH OTHER GOODS		
	COMPLETE X	PARTIAL	UZ3800		
CUSTOMER	FOR	DEST	FINISHED GOODS LOCATION		
COMMON/FRT-CCX	PPD		WARN LABEL:1001		
DATE OF LADING			063496-4		

PART DESCRIPTION

061-T6 FLAT ALUMINUM SHEET, 1040-X 48 X 144
 PART AEROSPACE, NO PROCESSING - 48" X 144" Mill
 dimensions., Test Results Attn to: QA Department.
 MEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL
 REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

Rec'd 4/21

SPECIAL INSTRUCTIONS									
Shipping, do not place any packages or goods on top of our material."									
SCRAP	FILLED BY		PACKED BY		Q/A AUDIT				
	SC								
DELIVER RECEIVING HOURS	MAX SKID WEIGHT		LOADING INSTRUCTIONS			MAXIMUM BUNDLE WEIGHT			
8-3	100		HAND, CRANE, FORK, DOCK			200			
PAKS	CASES	CUSHP	PKGS	SKIDS	BOLS	TUBES	CTNS	FLAT	COILS
INSPECTION	RECORD								

TEST RESULTS -----

CERTIFICATE OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.
 Our products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds
 Call 248-233-5682. We hereby certify that the material above complies with the following specifications:

AMS 4027 ASTM-B209 ROHS COMPLIANT

QTY	QUANTITY UOM	VENDOR	VEND PO	HEAT/LOT	PCS	TAG NO	QUANTITY UOM	VENDOR	VEND PO	HEAT/LOT	PCS
52.00	LB	CORUS	00C1837	7124901							

M-100-742